

# Work Order ID 99223

April-03-13 1:06:30 PM

\*99223\*

Ship tomorrow Page 1

Item ID: D4791-7 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: PRELIM Stop \*NS2\*  
 Item Name: Aft Flange  
 Start Date: 4/03/13 Start Qty: 2.00 \*2\* Cust Item ID: PRELIMINARY ISSUE  
 Required Date: 4/03/13 Req'd Qty: 2.00 \*2\* Customer:  
 Reference:

Approvals: Process Plan: VNF Date: 13-4-03 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4791	PA3								
100		0.00							
*100*	FLOW WATER JET								
Waterjet	Memo	0.00							
FLOW CNC Waterjet	1-Cut as per Dwg D4791 Dwg Rev: <u>PA3</u> Prog Rev: <u>PA3</u> 2-Deburr as required								
110		0.00							
*110*	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

DAS  
05  
9-89

13-04-03

DAS  
05  
9-89

13-04-03

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Page 2

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 Start Date: 4/03/13 Start Qty: 2.00 **\*2\*** Cust Item ID:  
 Required Date: 4/03/13 Req'd Qty: 2.00 **\*2\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 <b>*120*</b> QC Quality Control	QC8- Inspect parts - second check  Memo	0.00 0.00							
						3			Inspected as per our PAB
160 <b>*160*</b> HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00 0.00							
						3			1344
170 <b>*170*</b> QC Quality Control	QC7-Inspect Chemical Conversion Coat  Memo	0.00 0.00							
						3			

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Revision ID: PRELIM Stop \*NS2\*  
Item Name: Aft Flange

Start Date: 4/03/13 Start Qty: 2.00 \*2\* Cust Item ID:  
Required Date: 4/03/13 Req'd Qty: 2.00 \*2\* Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

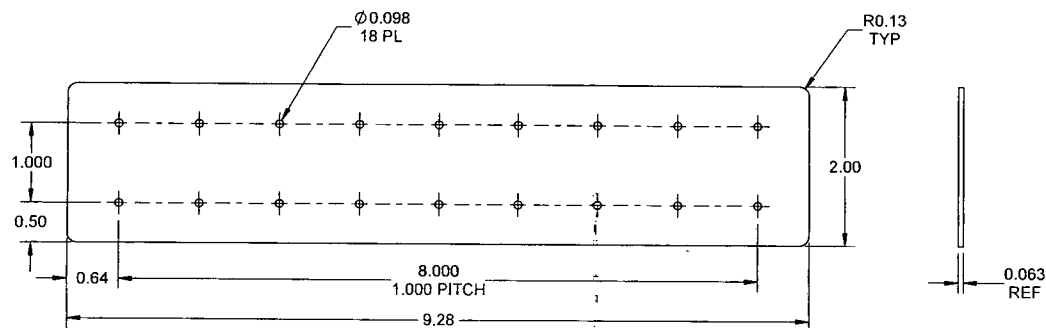
Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180	Identify as per dwg & Stock Location: _____	0.00							
*180*									
Packaging	Memo	0.00							
Packaging									
190	QC21- Final Inspection - Work Order Release	0.00							
*190*									
QC	Memo	0.00							
Quality Control									

POSITIVE RECALL

EFFECTIVE \_\_\_\_\_ AUTH \_\_\_\_\_

RELEASED \_\_\_\_\_ DATE \_\_\_\_\_

MF  
13-4-4



**D4791-7 FLANGE**

**NOTES:**

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.063 THICK  
PER QQ-A-250/11 OR AMS-QQ-A-250/11  
OR AMS 4025 OR AMS 4027 OR ASTM B209  
REF DART SPEC M2024T3S.063 OR M6061T6S.063  
OR  
2024-T3 ALUMINUM SHEET, 0.063 THICK  
QQ-A-250/4 OR AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209  
REF DART SPEC M6061T6S.063 OR M2024T3S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.11 lbs

**PRELIMINARY ISSUE**

*RF* 13.03.02

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>DC</i>	DRAWING NO. <b>D4791</b>	REV. PA3
MFG. APPR.		TITLE <b>AFT C-CHANNEL ASSEMBLY</b>	SHEET 11 OF 11
APPROVED		SCALE	NTS
DE APPR.		COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON OR ENTITY WITHOUT PERMISSION FROM DART AEROSPACE LTD	
DATE	13.03.02		



# Receiving Report

Date: 12-12-11  
 Supplier: Campi

Batch No: 124003  
 Dart P/O: 186008

Packing Slip: Yes ☒ No ☐  
 Invoice: Yes ☒ No ☐  
 Receipt: Cash ☐ Cr ☒

Release Note Attached: Yes ☒ No ☐ N/A ☐  
 Waybill Attached: Yes ☐ No ☒ N/A ☐  
 Shipment Complete: Yes ☒ No ☐ N/A ☐  
 QC6 Inspection OK N/A ☒  
 Work Order 2.2 N/A ☒

## Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments

Initials of receiver (if shipment OK) Level 12

SP

Production/Admin: 12-12-11  
 Date  
 Received/Costing SP  
 Initial

Location \_\_\_\_\_

# Purchase Order Receipt Listing

Page 1 of 1

Tuesday, December 11, 2012 2:31:49 PM

All amounts are calculated in domestic currency.

All Vendors PO ID PO18608 Receipt Dates from 12/11/2012 to 12/11/2012 All Line Item Types  
All Item ID/GL/WOs All Rec. Employees All Currencies  
Grouped by Vendor ID

Purchase Order ID/ Curr Type	Line Nbr/ Insp Req	Project ID	Reference/ Description/ Cert Std	PO U/M/ Stock U/M	Required Date Required Qty	Recv Date/ Recv Emp	Recv Qty (PO U/M)	Cost Per Unit/ Recv Value	Inspected Qty/ Rejected Qty (PO U/M)	MRB Qty/ MRB Reject Qty	Book Amt
---------------------------------	-----------------------	------------	--	----------------------	-------------------------------	------------------------	----------------------	------------------------------	--	----------------------------	----------

VendorID\Vendor Name		VC-CAM002	Campi Steel								
PO18608	1		M6061T6S.063	sf	12/17/2012	12/11/2012	288.0000	\$3.40	0.0000	0	\$978.22
CAD	No		6061-T6-063 Sheet	sf	288.0000	DESJ02		\$978.22	0.0000	0	
			124003								

Total Received Quantity:	288.0000
Total Qty to Inspect (PO U/M):	0.0000
Total Reject Quantity:	0.0000
Total Receipt Value:	\$978.22
Total Balance Due Quantity:	0.0000

935, boul. du Havre  
Valleyfield (Québec)  
J6S 5L1

**TÉLÉPHONE : 451 4248**  
**FAX : 450 377-5696**

**MONTREAL : 514 336-4248**  
**FAX : 514 336-4246**

**DISTRIBUTEUR D'ACIER ET MÉTALLS SPÉCIALISÉS**  
**STEEL AND SPECIALTY METALS DISTRIBUTOR**

**ONTARIO : 1 800 667-4248**  
**FAX : 1 866 456-4242**

*On a du Savoir "FER"*

**VENDU À / SOLD TO:**

613-632-5200

613-632-1053

**EXPÉDIEZ À / SHIP TO:**

DART AEROSPACE LTD  
1270 ABERDEEN STREET  
HAWKESBURY,  
ONTARIO  
K6A 1K7

DART AEROSPACE LTD  
1270 ABERDEEN STREET  
HAWKESBURY,  
ONTARIO  
K6A 1K7

EQUIP: 001 LIFT

COMMANDE  
ORDER

N° 209049

DATE: \_\_\_\_\_

07/12/12

**BON DE LIVRAISON**  
**PACKING SLIP**

No

DATE DE LIVRAISON  
DELIVERY DATE

11/12/12

VOTRE N° DE COMMANDE / YOUR PO. N°	VENDEUR / SALESM.	CODE CLIENT / CUST. CODE	EXPEDIE PAR / SHIP VIA	TERMES / TERMS	TERR.	REMARQUES / REMARKS	PAGE N°
P018600	V	DAER		NET 30 JOURS	2R		001

[illegible]

* Unités de mesure Units of measure:	CLB Cent livres Hundred pounds	CPI Cent pieds Hundred feet	UN Unit Unit	PI Pied Foot	PC Pied carré Square foot
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POIDS TOTAL  
TOTAL WEIGHT

## CONDITIONS

LES MATERIAUX LIVRES ET FACTURES IELS QUE DÉCRITS DEVREMENT LA PROPRIÉTÉ DE "MISTER CAMPING". JUSQU'À PARFAIT PAIEMENT COMPLET, LE CLIENT RISQUERA D'ÊTRE CHARGÉ DES CHARGES DE LA CROCHÈTE. LA GARANTIE DE QUALITÉ DU MATERIAU EST LA MÊME QUE CELLE DU FABRICANT. LE CLIENT S'ENGAGE À RÉPONDRE À DES QUESTIONS SUIVANTES : JET 30 JOURS DE LA DATE DE FACTURATION. J'Y TOUJOURS IMPRIME DANS LES 30 JOURS ENTRAÎNE DES FRAIS DE 2% PAR MOIS (24% PAR ANNÉE) OÙ, ACCEPTÉ DE FAIRE, J'Y TOUJOURS DÉCÈDÉ L'UNE OU L'AUTRE DES OBLIGATIONS EN VERTU DU PRÉSENT CONTRAT ENTRAÎNE LA DÉCHARGE DU DÉTERME ET PERMET AU Vendeur, À SA CHOIX, DE RÉCLAMER TOUJOURS DU PRÉSENT VENTE DE REPRIRE LE BEN VENDOR. J'Y TOUJOURS L'AMORATION D'ÊTRE FAITE DANS LES CINQ JOURS SUivant LA PRÉSENTATION DE CE DOCUMENT. J'Y TOUJOURS MARCHANDISE ENVOYÉE, ALORS QUE DU QUANTITÉ PEUT ÊTRE ÉCHANGÉ. J'ALCUN RETOUR DE LA MARCHANDISE NE SERA ACCEPTÉ SANS NOTRE AUTORISATION. J'Y TOUJOURS MARCHANDISE POUR J'Y TOUJOURS SUIVET À DES FRAIS DE MAINTIEN DE 26%.

## CONDITIONS

**ALL SOLD AND DELIVERED MATERIALS REMAIN THE PROPERTY OF "AQUER CAMPING," UNTIL PAYMENT IS MADE IN FULL; COMPLETE AND CASHED ALL-LOST MATERIALS ARE TO BE RETURNED TO THE SELLER. ALL MATERIALS BEAR THE SAME WARRANTY AS GIVEN BY THE MANUFACTURER. THE BUYER AGREES TO ACCEPT ALL RETURNS ON THE FOLLOWING CONDITIONS: IF A RETURN IS REQUESTED FOR ANY REASON, THE BUYER AGREES TO PAY THE ADMINISTRATIVE CHARGES OF 20% PER MONTH, PLUS 10% PER ANNUM ON ALL ACCOUNTS OVER DUE DATE. IF THE BUYER REQUESTS A REFUND, THIS CONTRACT WILL LEAD TO PAYMENT BY ACCREDITATION AND PERMITS TO THE SELLER, AT HIS CHOICE, TO CLAIM FOR A BALANCE DUE FROM THE REPOSSESSION OF THE GOODS SOLD. ANY CLAIM MUST BE MADE WITHIN FIVE DAYS OF THIS DOCUMENT ENCLOSED. ANY MERCHANDISE THAT HAS BEEN DAMAGED, CUT OR MODIFIED CANNOT BE RETURNED. ALL GOODS RETURNED MUST BE WITH OUR AUTHORITY TO AVOID BE SUBJECT TO A 20% RESTOCKING CHARGE.**

MARCHANDISE RECUE EN BONNE CONDITION MERCHANDISE RECEIVED IN GOOD CONDITION

PRÉPARÉ / PREPARED.	VÉRIFIÉ / VERIFIED	LIVRÉ / DELIVERED	HEURE / TIME
PAR BY	PAR BY	PAR BY	

<b>X</b>	<i>Shad Gail</i>	A/Y	M/M	J/D

SIGNATURE DU CLIENT / CUSTOMER'S SIGNATURE

**銀沙**

**SOUS-TOTAL**  
**SUB TOTAL**

T.P.S.  
G.S.T

T.V.Q. / TVH  
Q.S.T. / H.S.T

**TOTAL**



# CERTIFIED INSPECTION REPORT

**Alcoa Inc.**

**DAVENPORT WORKS 4879 State Street Bettendorf, IA 52722**

Ship From: RIVERDALE, IA.

We hereby certify that the material covered by this certificate has been inspected with, and has been found to meet the applicable requirements described therein, including any specifications forming a part of the description and that samples representative of the material met the composition limits and had the mechanical properties shown on the face of this sheet.

This test report shall not be reproduced except in full, without the written approval of the Quality Department. No alteration, addition or other change is authorized to be made to this certificate. The recording of false, fictitious, or otherwise fraudulent statements or entries on this certificate by any recipient may be punished as a felony under applicable law.

Per:

*Rob Woodall*

Rob Woodall  
Director of Manufacturing Davenport Works

*Terrance Thom*

Terrance Thom  
Quality Assurance Manager

1181354 Ship Date	0 B.I. No.	Invoice No.	Alcoa No. Item
2012-05-16	7036272	00000	1000363803-3 DPE-63803-3
P.O. No./Govt Contract No.	Customer	Alcoa Item	
C64813 Ln#: 3			

Page 1 of 2

Ship To:

Item Description  
0.063 IN TK (+0.0000 - .0035) X 48.0 IN W (+.125 - .125) X 144.0 IN LN (+.15625 - .15625) (N) A/T 6061-  
T6 PLAT SHEET FOR DISTRIBUTORS TOLERANCE  
GUARANTEED. AMS4027 REV N EXC MRK ASME-SB-  
209 REV 11 EXC MRK ASTM B209 REV 10  
CMMPO25 REV U ((MARKED)) KRAFT PAPER  
INTERLEAVED MAX GROSS  
SKID WGT: 4500 LB QUAN TOL +/-30 %  
CQR 0222751 REV 07 CUST REQ 12-05-  
12 \*\*\* W/E 12-05-26 \*\*\*

Num	Package Ticket	Lot	Weight	Quantity	UOM	Inspector Clock Numbers
1	411520	463274	4081	100	PC	27649 47004 0892116
2	411522	463274	4087	100	PC	27649 47004 0892117
3	411528	463274	3105	76	PC	27649 47004 0892118
			11273	276		

Notes for CQR: 0222751.7

PRODUCT PRODUCED TO THE REQUIREMENTS OF AMS4027 REV N ALSO MEET THE REQUIREMENTS OF AMS-QQ-A-250\_11 ORIGINAL REVISIO N DATED 1997-08-01.

CQR: 0222751.7 -Specification Limits

Temp	Dir	Max	Min	UTS KSI	TYS KSI	EL4D PCT
T6	Long Transv.			42.0	35.0	10

DAV  
05  
12-12-12

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Per

*Rob Woodall*

Rob Woodall

Director of Manufacturing Davenport Works

*Terence Thom*

Terence Thom

Quality Assurance Manager

1381354

Ship Date

0

B.L. No.

Invoice No.

Alcoa No. Item

2012-05-16

7036272

00000

1000363803-3

DPE-63803-3

P.O. No./Govt Contract No.

Customer

Alcoa Item

C64813 Ln#: 3

Page 2 of 2

CQR: 0222751.7 -Specification Limits (cont.)

Chemical Composition	SI	FE	CU	MN	MG	CR	ZN	TI	Other	Other	Back	Total	Aluminum
Max	0.8	0.7	0.40	0.15	1.2	0.35	0.25	0.15	0.05	0.15			
Min	0.40		0.15		0.8	0.04							

Alloy 6061  
Lot: 463274 - Mechanical, Physical, Metallography, Quantometer Results

REMAIN

Temp	Dir	Test	UTS	TYS	EL4D
16	Long Transv.	10	51.1	44.8	12.1
			50.9	44.7	11.6
			51	44.7	11.5
			51	44.7	11
			51	44.7	12.2
			50.5	44	11.7
			50.7	44.4	11.3
			50.5	44.2	11.5
			50.5	44.2	11
			50.6	44.4	11.6

Cast Number	Chemical - OES	SI	FE	CU	MN	MG	CR	ZN	TI
H9479082	Actuals	0.66	0.4	0.27	0.06	0.9	0.17	0.03	0.02

This material was melted in the United States or a Qualifying Country [REF DPAKS 225.872.1(a)]; it was manufactured in the United States



Dart Aerospace Ltd.  
1270 Aberdeen Street  
Hawkesbury, ON K6A 1K7  
Tel: 613 632 9577  
Fax: 613 632 1053

## PURCHASE ORDER

Purchase Order ID PO18608

Purchase Order Date 12/07/12

PO Print Date 12/07/12

Page Number 1 of 1

Order From :

VC-CAM002

CAMPI STEEL  
935 BOUL. DU HAVRE  
VALLEYFIELD, QC J6S 5L1  
CA

Contact Name

Vendor Phone 800 667 4248

Vendor Fax 450 377 5696

Vendor Account Nbr

Buyer

Chantal Lavoie

Requisition Nbr

Tax Resale Nbr

10127-2607

Terms

Net 30

Currency

CAD

FOB

Destination-Collect

Ship To :

DART AEROSPACE LTD

1270 ABERDEEN  
HAWKESBURY, ON K6A 1K7  
CANADA

**FAXED**  
613 632 1053

Line Nbr	Reference Revision ID Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	Req Qty/ Unit of Measure	Ship Method	Unit Price	Extended Price
1	M6061T6S.063	6061-T6 .063 Sheet	12/17/12 Yes	288.00 sf	Yours ppd	\$3.3750	\$972.00

Special Inst: MATERIAL: 6061-T6/T62 ALUMINUM  
SHEET  
AS PER QQ-A-250/11 OR AMS-QQ-A-  
250/11 OR  
AMS 4025 OR AMS 4027 OR ASTM B209

NOTE: RECEIVING DEPARTMENT WILL  
BE CLOSE FOR INVENTORY ON  
DECEMBER 13 AND 14

PO Total:

\$972.00

**MATERIAL CERTIFICATION  
REQ'D UPON DELIVERY**

Change Nbr: 2

Change Date: 12/07/12

CL  
No substitution or deviation without  
consent.  
Certificate of Conformity or Material  
Certification required - YES NO